

shp May 4th

Work Order ID 81297

81297

Page 1

March-12-12 4:42:12 PM

Item ID: D350-591-311

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, Long LH

Start Date: 12/03/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/13

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

SP

Schulze HJ for MLJ 12-4-25
(10)

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod 119785
120169

3-Grind End Plate flush

10 φ 12.04.11

Ac
12.04.14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

10

10

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

120	QC9- Inspect visual per QSI004- Fusion Welds	0.00
-----	--	------

120

QC Memo

0.00

Quality Control

130	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

130

QC Memo

0.00

Quality Control

140	Chemical Conversion Coat per QSI005 4.1	0.00
-----	---	------

140

HandFinish Memo

0.00

Hand Finishing

710 0 RF 12-04-15

12 - 04 - 14 (10)

X10

Ac
12.04.16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D350-591-311

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Setup Start ***NS1***

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Stop ***NS2***

Item Name: Heli-Access-Step, Long LH

Start Date: 12/03/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				10 x10	0		ll 12.04.16
150									
QC	Memo	0.00							
Quality Control									
180	Large Fab	0.00				10 x10	0		Ae 12.04.16
180									
Large Fab	Memo	0.00							
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								Ae 12.04.16
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding →								ll 12.04.17
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod <u>119135</u>								
	6-Grind End Plate flush								Ae 12.04.17
	7-Install last rivet as per Dwg.								

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order 1D 81297

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March-12-12 4:42:12 PM

Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step, Long LH
 Start Date: 12/03/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 04/05/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							

Sizler/18

Sizler/18

*(X10)
LH*

*10 2/6/12 M-H
12-4-19*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 10.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
220 Powdercoat Powder Coating	Memo START TIME: 8:30 OVEN TEMPERATURE: 320°F FINISH TIME: 9:00	0.00				10X	✓		M-F 12/04/20
230	Wing Walk as per dwg QSI005 4.4 Batch 20902	0.00							
230 HandFinish Hand Finishing	Memo	0.00				10	✗	28	12/04/24
240	QC3- Inspect Part Finish	0.00							
240 QC Quality Control	Memo	0.00				10	φ	124-24	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/03/2012 **Start Qty:** 10.00 ***10***

Cust Item ID:

Required Date: 04/05/2012 **Req'd Qty:** 10.00 ***10***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

250	Pick Kit	0.00			
250					
Packaging	Memo	0.00	10	12/04/25	JB

Packaging

260 QC4- 100% Inspect kits for completeness

260			0.00	8.24/76
QC	Memo			

Quality Control

270	0.00
-----	------

270	Packaging		
Packaging		Memo	0.00

Packaging	Identify and pack for shipping as per PPPD350-591-311
-----------	---

Location: tail

Rev B

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order-ID 81297***81297***

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Item ID: D350-591-311

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Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step, Long LH

Start Date: 12/03/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:


Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

12/4/30 

K1204-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Dart Aerospace Ltd

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Picklist Print

March-12-12 4:42:16 PM

Page 2

Work Order ID: 81297

81297

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 12/03/2012

Required Date: 04/05/2012

Start Qty: 10.00

Required Qty: 10.00

D3066-1 Manufactured No

180 Each 66.0000 2 20

D3066-1

Spacer

** ~~381968 (x20) Ae 12.04.16~~

Location

Loc Qty

Loc Code

WA

66

78605

66

381968 (x20) Ae 12.04.16

MS20600-AD4W4 Purchased No

180 Each 2,478.000 16 160

MS20600-AD4W4

Rivets

** ~~M121340 (x160) Ae 12.04.16~~

Location

Loc Qty

Loc Code

ST321

2473

116188

59

117364

253

117601

200

117885

195

118840

1089

119860

30

119883

155

120308

72

120769

420

WA018

5

116712

5

M121340 (x160) Ae 12.04.16

D3065-041 Manufactured No

180 Each 44.0000 1 10

D3065-041

Step Leg Assembly Hi

** ~~B78798 (x10) Ae 12.04.16~~

Location

Loc Qty

Loc Code

WA

44

66149

0

78799

40

79336

1

79419

3

B78798 (x10) Ae 12.04.16

March-12-12 4:42:16 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Page 3

Work Order ID: 81297

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

81297

D350-591-311

Start Date: 12/03/2012

Required Date: 04/05/2012

Start Qty: 10.00

Required Qty: 10.00

D3067-1 Manufactured No

180 Each 178.0000 1 10

D3067-1

End Plate

**

12.04.17

Location	Loc Qty	Loc Code
WA	152	
78608	92	
80881	60	<i>10</i>
WA016	26	
67582	2	
68214	1	
79607	23	

AN3-35A Purchased No

250 Each 147.0000 2 20 ✓

AN3-35A

SHO Bolt

**

121068 JB

Location	Loc Qty	Loc Code
ST353	147	
120187	47	
120644	50	
120717	50	

D3235-1 Manufactured No

250 Each 145.0000 2 20 ✓

D3235-1

Mounting Lug

**

JB

Location	Loc Qty	Loc Code
ST	145	
78787	145	<i>78787</i>

D3278-041 Manufactured No

250 Each 1.0000 1 10 ✓

D3278-041

Support Assembly

**

83361 JB 12/04/25

Location	Loc Qty	Loc Code
ST481	1	
78794	1	

March-12-12 4:42:16 PM

Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Page 4

Work Order ID: 81297

81297

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 12/03/2012

Required Date: 04/05/2012

Start Qty: 10.00

Required Qty: 10.00

AN960JD416 NAS1149D0463J Purchased

No

250

Each

14.0000

16

160

**

121255 JB

AN960JD416

Washer

Location

Loc Qty

Loc Code

ST351

14

116289

14

AN960JD516 NAS1149D0563J Purchased

No

250

Each

0.0000

4

40

**

118614 JB

AN960JD516

Washer

AN5-36A Purchased

No

250

Each

162.0000

2

20

**

JB

AN5-36A

Bolt

Location

Loc Qty

Loc Code

ST340

162

120187

112

120731

50

120187

D2618 Manufactured

No

250

Each

304.0000

2

20

**

JB

12/04/25

D2618

Bushing

Location

Loc Qty

Loc Code

ST012

304

76130

2

78537

102

80474

200

8x78537

12x80474

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 12/03/2012

Required Date: 04/05/2012

Start Qty: 10.00

Required Qty: 10.00

D2230-3

Manufactured No

250

Each

187.0000

4

40 ✓

D2230-3

Lug

**

81558 JA

Location

Loc Qty

Loc Code

ST480

187

53881

4

70973

1

80009

182

D2856-400

Manufactured No

250

f

202.0445

1.2

12 ✓

D2856-400

Abrasion Strip

**

JB

Location

Loc Qty

Loc Code

ST409

202.0445

63735

0.6696

68076

0.3149

71164

8.46

79551

192.6

79551

*** cut (2) at 7.20" (D2856-400-720) ***

MS21042L3

Purchased

No

250

Each

3,226.000

2

20 ✓

MS21042L3

Nut

**

121349 JB

12/04/25

Location

Loc Qty

Loc Code

ST300

3226

117441

16

117885

32

118451

5

118927

3

119017

2990

119075

180

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 12/03/2012

Required Date: 04/05/2012

Start Qty: 10.00

Required Qty: 10.00

AN4-13A Purchased No

250 Each

1,367.000 8 80 ✓

AN4-13A

Bolt

**

Location

Loc Qty

Loc Code

ST357

1367

119449

59

120187

408

120422

500

120770

400

120422

MS21042L5

Purchased No

250 Each

1,622.000 23 20 ✓

MS21042L 5

Nut

**

Location

Loc Qty

Loc Code

ST300

1622

116105

5

116548

43

117611

42

118179

32

119109

1500

119109

MS21042L4

Purchased No

250 Each

3,831.000 8 80 ✓

MS21042L 4

Nut

**

Location

Loc Qty

Loc Code

ST300

3831

117441

51

117601

157

118451

133

119017

200

119075

3290

119075

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4 40 ✓

AN960JD10

Washer

**

121243

12/04/24

March-12-12 4:42:17 PM

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART

DESIGN <i>QD</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. E SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07 06 04 - *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81297 *MLJ*
12/03/13

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QAWCRWO RevE



DESIGN	AP	DRAWN BY	JR	DART AEROSPACE LTD
CHECKED	CE	APPROVED	[Signature]	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. E
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20

DETAIL A



116.25
(CUT LENGTH OF D3272-1, REF)

108.93
(DIST FROM FIRST HOLE TO FWD FACE OF SUPPORT)

DETAIL B

1 D3219-1
SUPPORT
(2 PLACES)

D3272-1 STEP



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

81297

APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS

RIVET D3065-041
TO D3272-1 USING
MS20600AD4W4 RIVET
(16 PLACES)

1.36
(REF)

0.65
(REF)

GRIND FLUSH
(TYP)

3.375

(TYP)

D3219-1
SUPPORT
(REF)

D3067-1 END PLATE
(2 PLACES)

D3066-1 SPACER
(2 PLACES)

D3065-041
LEG ASSEMBLY

DETAIL A
(SCALE 1:5)

DETAIL B
(SCALE 1:5)

RELEASED

07.06.04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

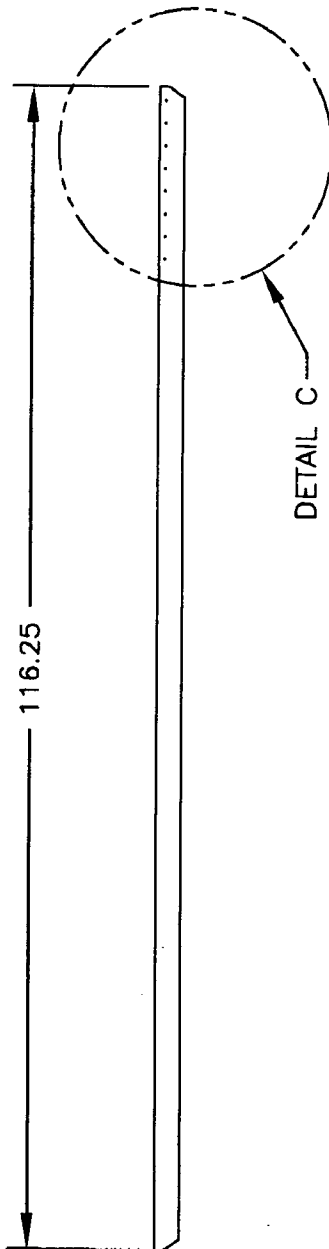
NOTE: Date & initial all entries

DART

DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

07.06.04 *[Signature]*

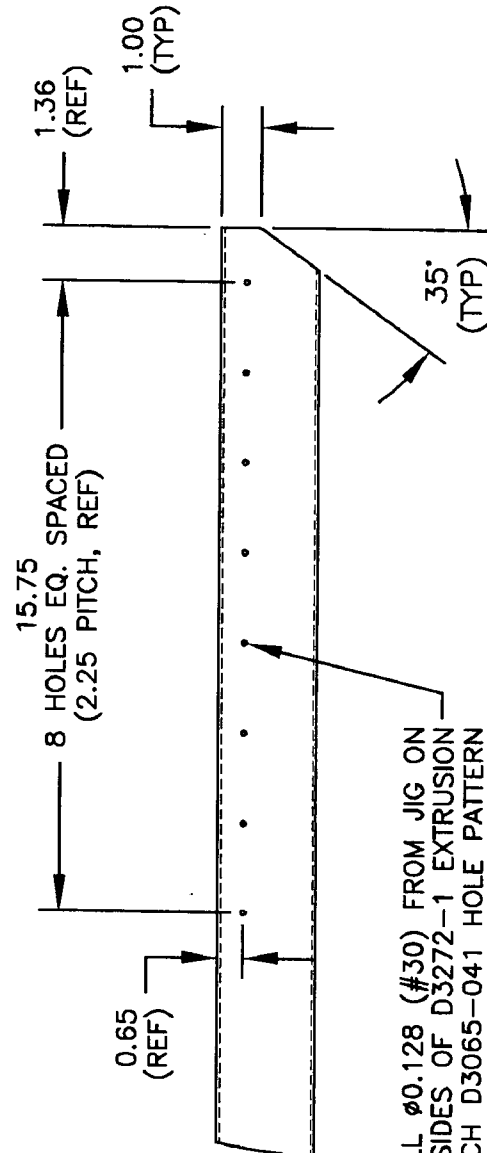


DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)

81297



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C

(SCALE 1:5)

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™ , Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™ , Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™ , Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™ , Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™ , Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™ , Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™ , Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™ , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	-4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.